

Del .750

Work Order ID 71869

Wednesday, July 13, 2011 11:02:35 AM



Page 1

Item ID:	D3953-9	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gas Spring Washer					
Start Date:	7/14/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	7/28/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>ME</u>	Date:	<u>11-07-13</u>	Tooling:		Date:	
	QC:		Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3953	C								

100



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA855 & DWG

FOLIO REV: C

DWG REV: 11/8/12

DEBURR

0.00

0.00

20

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11/8/12

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 71869

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Page 2

Item ID: D3953-9

Accept

Revision ID:

Item Name: Gas Spring Washer

Start Date: 7/14/2011 Start Qty: 20.00

Required Date: 7/28/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

Quality Control

0.00

CHK 11/08/03

21

130

Identify as per dwg & Stock Location: 96

0.00



Packaging

Memo

Packaging

0.00

11/8/03 SP (21)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

CHK 11/08/04

11-08-2 (21)

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Picklist Print

Page 1

Wednesday, July 13, 2011 11:02:32 AM

Work Order ID: 71869



Parent Item: D3953-9



Parent Item Name: Gas Spring Washer

Start Date: 7/14/2011


Required Date: 7/28/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC
as per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNRINR0.750 		Purchased				100	f	42.7980	0.05	1.052632			
Delrin Round Bar 0.75"													



21 10812

LocationLoc QtyLoc Code

MAT055

42.798

115472

7.5

116183

2.4

117273

9.958

117322

0.94

118066

22

3/21

Dart Aerospace Ltd

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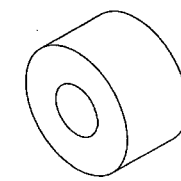
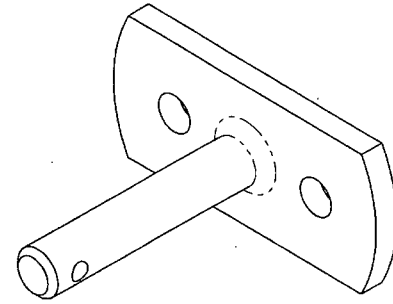
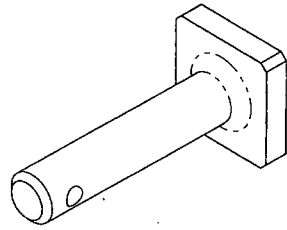
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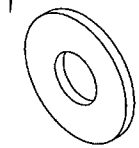
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



71869



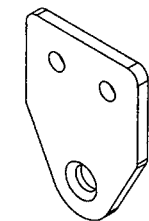
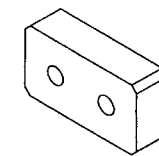
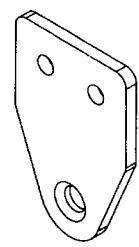
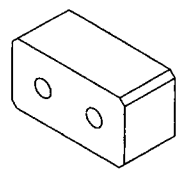
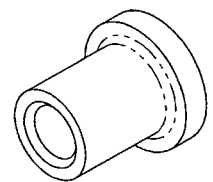
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



RELEASED
2010-07-26

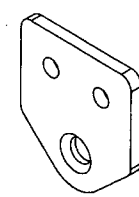
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

D3953-17 GAS SPRING SPACER
(SPLIT LID)

D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 1 & 4). CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4). C SYMM WAS C SYM ABOUT (C7-2, C7-4). SECTION C-C REPOSITIONED TO B2-4. REASON: ADDL PARTS REQD, DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED. REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3953	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	GAS SPRING LID COMPONENTS	NTS
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8 7 6 5 4 3 2 1

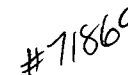
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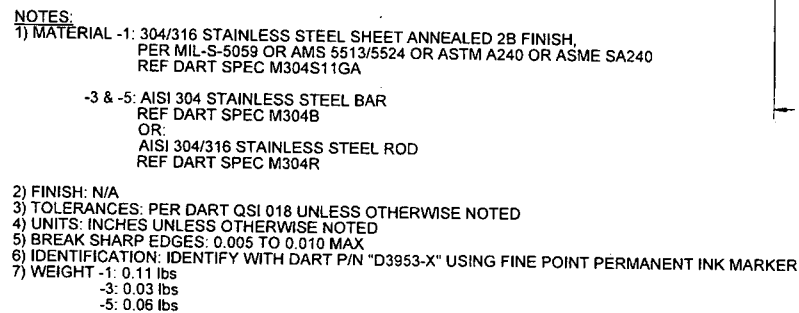
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NOTE: Date & initial all entries



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MFG. APPR.	<i>[Signature]</i>		NT
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

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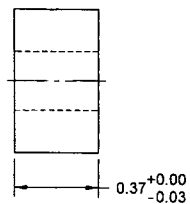
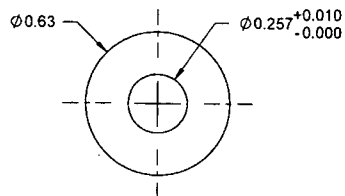
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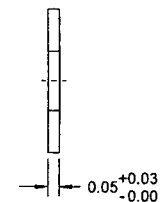
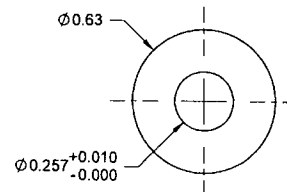
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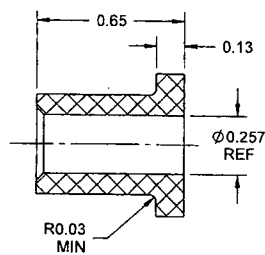
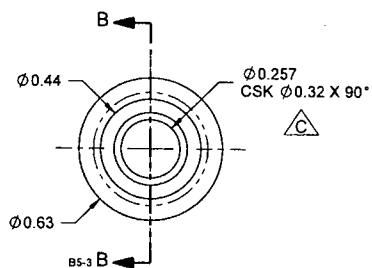
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

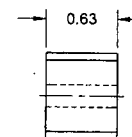
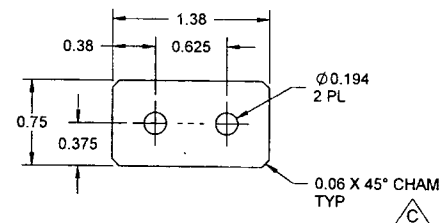


D3953-9 GAS SPRING WASHER



SECTION B-B 87-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV: C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
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DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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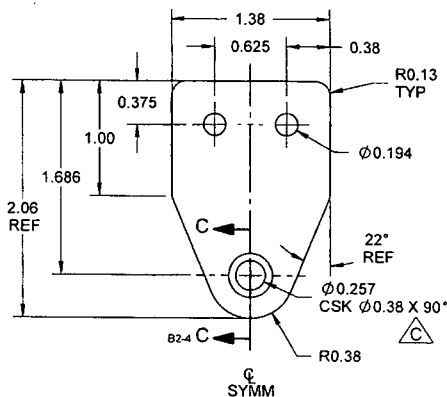
W/O:		WORK ORDER CHANGES					
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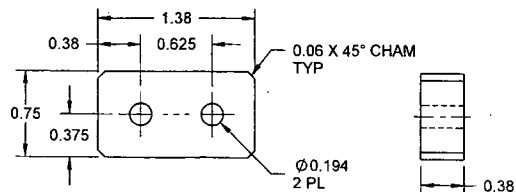
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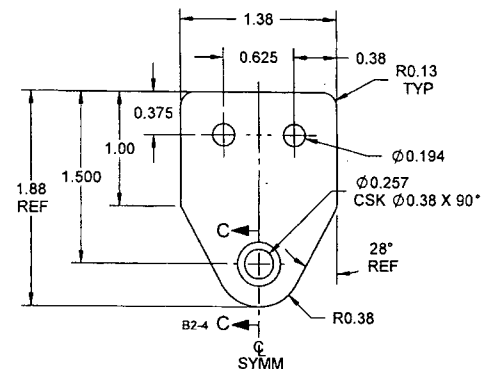
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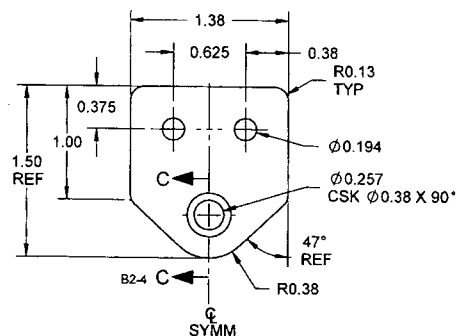
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



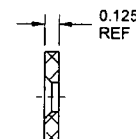
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

#71869

SECTION C-C

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CHECKED	<i>JP</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>JP</i>	D3953	SHEET 4 OF 4
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